

Split

ASAP!!

Work Order ID 58290-1

May 3, 2010 10:26:35 AM

Item ID: D2565-107

Accept

Revision ID:

Item Name: Strut

Start Date: 5/03/10

Start Qty: 10.00

Required Date: 5/05/10

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

QC:

Date: 10-5-03 Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00



Brake NC

Brake NC

NC BRAKE

Memo

Punch as per Dwg D2565 using DT 8313

0.00

SP 10/05/13

110

0.00



Small Fab

Small Fab

Small Fab

Memo

Debur

0.00

SP 10/05/13

(3)

120

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Split

(x3)

Work Order ID 58290

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Item ID: D2565-107

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Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Powdercoat

Powder Coating

Operation
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Memo

START TIME:

11:30 AM FINISH TIME:

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

OVEN TEMPERATURE:

400°F

7 JH 10/05/18

3 0

140



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

3 BR 10-5-18.

150



Packaging

Packaging

Identify as per dwg & Stock Location: 270

Memo

0.00

0.00

Per 10/5/18 (3)

Work Order ID 58290

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Item ID: D2565-107

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Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



Accept



Setup Start



Stop



Cust Item ID:

Customer:



10/05/18
MK
10-5-18

Picklist Print

May 3, 2010 10:26:35 AM

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Work Order ID: 58290



Parent Item: D2565-107



Parent Item Name: Strut

Start Date: 5/03/10

Required Date: 5/05/10

Comments: IPP: F 02.04.16 Added dwg Rev.C1 NG

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	303.4562	1.1191			



304 RD Tube .750 x .049W



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	275.5927	
108498	0	
114482	275.5927	
MAT017	27.8635	
109314	9.33	
110113	5.29	
112800	13.2435	

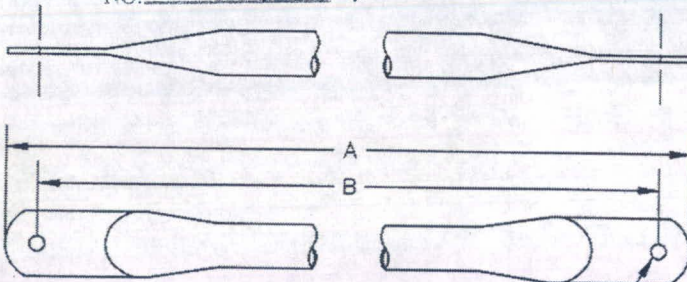
13 SB r/ds/13 (10)

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58290 *BS10-5-03*



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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